

Work Order ID 115327

115327

Page 1

March-25-14 9:58:35 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-03-25 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | |
|----------|--------------|
| Draw Nbr | Revision Nbr |
|----------|--------------|

| | |
|-----------|---|
| D2750-042 | G |
|-----------|---|

| | |
|-------|---|
| D3492 | C |
|-------|---|

100

Document Control

0.00

DAS
31
9-89

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle:

89.4°

BE14-04-16

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

B115327RH

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Start Date: 3/25/14 Start Qty: 1.00 ***1***

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Reference:

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Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

*BE 14-04-02*2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8- Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail L to 0.500" (8 holes per side)9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

10- Open up holes of Detail J to 0.297" (total of 2 holes per side)

BE 14-04-16

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(1) 14-04-16

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Revision ID: Stop *NS2*

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Start Date: 3/25/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 *1* Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 150 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

① / 14-4-16 DGL

BE 14-04-16



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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 4/08/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | Skidtubes | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | <p>1- Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</p> <p>2- Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</p> <p>3- Open float holes to .500" (4 per Side)</p> <p>4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</p> <p>5- Deburr and blow out all chips from inside of tube</p> <p>6- Prepare tube for welding, remove alodine as required.</p> <p>7- Bond web D2739 in place as per QSI015 A/R Sikaflex-291 batch: <u>129026</u> exp. date: <u>7/10/09</u></p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M12B385</u></p> <p>9- At section AP-AP drill out x-bolt spacer to 0.404"</p> <p>10- Grind welds flush as per Dwg D2750</p> <p>11- Spot face ground handling holes section (total of 4 places per side) as per</p> | | | | | | | | |

14-4-16 DGC

BE14-04-21
 14-4-21 JLL
 DC 11/04/21

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Start Date: 3/25/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/08/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

7

DC 14/04/21

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Smp
14/4/22

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Smp
14/4/22

Quality Control

VERIFY C'BOARD IS GOOD

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1x d of 14/05/15

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Item ID: D350-636-012

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Start Date: 3/25/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/08/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241

BATCH: 1A128569

EXP DATE: 2/1/12

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 1K111621

5-Coat all exposed fasteners with "LPS Procyon"
batch: 1K11290

240

240

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

AS

27

9-89

14/5/27

1R7C 4 21/03/14
NAS 1611-010 / M 12 8395 x8
NAS 1611-013 / M 12 8395 x8
PLM 14-06-03

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 250 | Pick Kit | 0.00 | | | | | | | |
| *250* | | | | | | 1x | | 14-5-27 | DAS 26 9:59 |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 260 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *260* | | | | | DAS 31 9:59 | 1 | | 14-05-28 | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 270 | Packaging | 0.00 | | | | | | | |
| *270* | | | | | | 1 | | 14-06-10 | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Package as per PPP D350-636-012 | | | | | | | | |
| | F6072 | | | | | | | | |

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Start Date: 3/25/14 Start Qty: 1.00 *1*

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-06-10

APR 4-6-10

Picklist Print

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Work Order ID: 115327

115327

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
AS PER REV F JLM 13-08-22 VERIFIED BY:DD
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
594 DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-3-BENT

Manufactured No

110

Each

6.0000

1

1

D2600-3-BFNT

Extrusion Bent

Location

Loc Qty

Loc Code

LG

6

111091

5

111606

1

D2744

Manufactured No

110

Each

10.0000

1

1

D2744

Cap

Location

Loc Qty

Loc Code

LG001

10

100398

10

8/21/14-04-02
B112976 x1

8/21/14-04-10
B115440 x1

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No 160 Each 28.0000 1 1

D2739

350 I Beam

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 21 | |
| 110835 | 1 | |
| 111094 | 9 | |
| 111609 | 1 | |
| 113252 | 10 | |
| LG002 | 7 | |
| 112596 | 7 | |

D2743 Manufactured No 160 Each 247.0000 8 8

D2743

Crossbolt Spacer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 246 | |
| 111570 | 125 | |
| 112729 | 121 | |
| LG001 | 1 | |
| 109799 | 1 | |

D3490-3 Manufactured No 160 Each 88.0000 4 4

D3490-3

Cross Bolt Spacer

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 88 | |
| 112736 | 88 | |

Picklist Print

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

121.0000

4

4

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

37

112737

37

LG001

84

109932

84

D3631-1

Manufactured No

230

Each

176.0000

8

8

D3631-1

Washer

**

Location

Loc Qty

Loc Code

FP001

176

110258

16

111019

60

113164

100

D3791-1

Manufactured No

230

Each

22.0000

1

1

D3791-1

Wearpad

**

Location

Loc Qty

Loc Code

FP002

22

110982

19

112413

3

DE 14-04-21
B116358 x4

HL 14/05/14

HL 14/05/14

y 8

x 1

Picklist Print

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

21.0000

1

1

D3793-3

Wearplate Aft

HL 11/05/14

Location

Loc Qty

Loc Code

FP001

1

13115604

104212

1

FP002

20

110887

12

113035

8

MS21043-6

Purchased No

230

Each

326.0000

4

4

MS21043-6

NUT

HL 11/03/14

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

56

m127255

56

ST509

250

m127813

250

D3794-1

Manufactured No

230

Each

27.0000

1

1

D3794-1

Gasket Fwd

HL 11/05/14

Location

Loc Qty

Loc Code

FP001

27

109207

1

111574

13

112521

2

113203

11

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

303.0000

8

8

NAS1611-010

O-RING

**

22 11/05/14

Location

Loc Qty

Loc Code

FP001

303

m126988

3

m127813

4

m128375

288

m128388

8

x 9

D2741

Manufactured

No

250

Each

17.0000

1

D2741

Blade

**

14-5-27
B115522

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

6

107206

2

110710

4

DAS
31
9-89

NAS1515H3L

Purchased

No

230

Each

295.0000

4

4

***NAS1515H3I ***

Washer

**

22 11/05/14

Location

Loc Qty

Loc Code

FG

36

102472

36

ST297

259

m127831

259

vd

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

344.0000

8

8

NAS1611-013

O-RING

**

Handwritten signature

Location

Loc Qty

Loc Code

FP001

344

m128375

344

AN3C6A

Purchased

No

230

Each

395.0000

4

4

AN3C6A

Bolt

**

Handwritten signature

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

42

m128224

42

ST513

343

m125709

343

NAS1149C0832R

Purchased

No

230

Each

315.0000

1

1

NAS1149C0832R

Washer

**

Handwritten signature

Location

Loc Qty

Loc Code

ST292

315

122441

48

m114915

117

m125807

150

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

17.0000

1

1

D3536-25

Gasket Center

Handwritten: 11/05/14

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

11

110652

1

111417

9

113008

1

Handwritten: B117687

Handwritten: x1

D3794-3

Manufactured No

230

Each

5.0000

1

1

D3794-3

Gasket Aft

Handwritten: 11/05/14

Location

Loc Qty

Loc Code

FP001

5

113060

5

Handwritten: B115659

Handwritten: x1

AN3C5A

Purchased No

230

Each

851.0000

34

34

AN3C5A

Bolt

Handwritten: 11/05/14

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

846

M128057

846

Handwritten: M128973

Handwritten: xBd

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

74.0000

3

3

D3537-1

Wearpad

HL 11/05/14

Location

Loc Qty

Loc Code

FG

18

B113229

V3

79833

8

88562

10

FP001

56

113839

1

114585

55

D3535-25

Manufactured No

230

Each

25.0000

1

1

D3535-25

Wearplate Center

HL 11/05/14

Location

Loc Qty

Loc Code

FG

2

B115750

X1

95077

2

FP002

23

110193

1

110744

1

112385

5

113120

16

D3492-3

Manufactured No

230

Each

172.0000

8

8

D3492-3

Plug

HL 11/04/14

Location

Loc Qty

Loc Code

FP001

172

104853

24

107331

1

111553

47

112739

100

B115802

X5

X3

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Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

10,470.00

38

38

NAS1149C0332R

WASHER

Handwritten: 11/05/14

Location

Loc Qty

Loc Code

GA

1033

125654

1033

ST292

5000

m128591

5000

st510

4437

m126319

61

m127306

2500

m127410

1850

m127831

26

Handwritten: x38

D3488-042

Manufactured

No

230

Each

5.0000

1

1

D3488-042

Blade Fitting RH

Handwritten: 11/05/14

Location

Loc Qty

Loc Code

FP001

5

Handwritten: B113592

106658

3

98887

2

Handwritten: x1

ALS4-1032-225

AELS8-1032-225 Purchased

No

230

Each

726.0000

38

38

ALS4-1032-225

Rivnut

Handwritten: 11/05/14

Location

Loc Qty

Loc Code

FG

30

M127028

30

Handwritten: M127028

Handwritten: x38

ST280

662

M127028

10

M128179

652

st555

34

M127092

34

March-25-14 9:58:39 AM

Shop Packet Print

Page 9

Picklist Print

March-25-14 9:58:39 AM

Page 10

Work Order ID: 115327

115327

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No 230 Each 176.0000 8 8

D3492-1

Plug

**

HL 11/05/14

Location

Loc Qty

Loc Code

FP001

176

111578

14

112738

162

x 8

D3793-1 Manufactured No 230 Each 8.0000 1 1

D3793-1

Wearplate Fwd

**

HL 11/05/14

Location

Loc Qty

Loc Code

FP002

8

110924

8

3115686

x 1

AN8C35A Purchased No 230 Each 80.0000 1 1

AN8C35A

Bolt

**

HL 11/05/14

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

76

m126293

29

m127061

1

m127823

46

x 1

MS21083C8 Purchased No 230 Each 31.0000 1 1

MS21083C8

Nut

**

HL 11/05/14

Location

Loc Qty

Loc Code

ST319

31

m127255

5

m128119

26

M128798

x 1

March-25-14 9:58:39 AM

Shop Packet Print

Page 10

Picklist Print

Page 11

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Work Order ID: 115327

115327

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

274.0000

8

8

D2745

Bushing

**

ll 1105/14

Location

Loc Qty

Loc Code

ST017

274

107336

4

110526

4

111554

124

113176

62

114874

80

yg

AN6C44A

Purchased No

230

Each

82.0000

4

4

AN6C44A

Bolt

**

ll 1105/14

Location

Loc Qty

Loc Code

FG

2

103964

2

ST341

80

m128319

80

11120700

xd

D3532-1

Manufactured No

250

Each

30.0000

2

2

D3532-1

Spacer

**

14-5-27
3115855

Location

Loc Qty

Loc Code

ST054

30

109803

18

113225

12

DAS
31
9-89

DAS
26
9-89

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Shop Packet Print

Page 11

Picklist Print

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Page 12

Work Order ID: 115327

115327

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

31.0000

2

(2)

MS21083C8

Nut

**

m128798.

DAS
26
9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST319

31

m127255

5

m128119

26

NAS1149D0863J

Purchased

No

250

Each

905.0000

2

2

NAS1149D0863J

Washer

**

DAS
26
9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

103

125484

103

ST510a

800

125268

600

125635

200

D3493-1

Manufactured

No

250

Each

249.0000

2

2

D3493-1

Washer

**

14-5-274

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

239

109105

159

112741

80

DAS
26
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

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Shop Packet Print

Page 12

Picklist Print

Page 13

March-25-14 9:58:40 AM

Work Order ID: 115327

115327

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 3/25/14

Required Date: 4/08/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

80.0000

2

2

AN8C21A

14-5-27

DAS
26
9-89

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

| | | |
|----------------|----|--|
| ST | 2 | |
| 123966 | 2 | |
| ST341 | 2 | |
| m127061 | 2 | |
| ST342 | 26 | |
| m128319 | 26 | |
| ST508 | 50 | |
| <u>m127823</u> | 50 | |

DAS

2X

March-25-14 9:58:40 AM

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Page 13

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

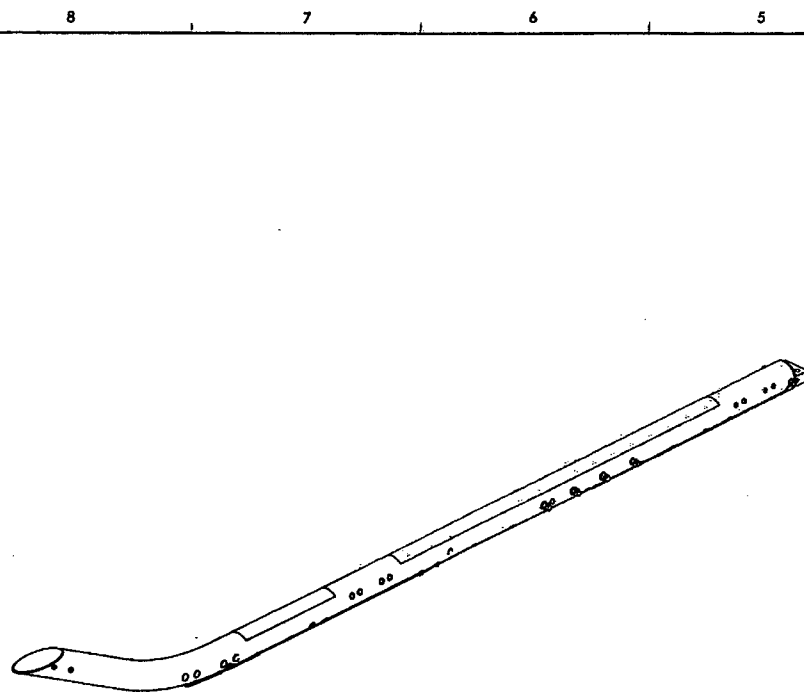
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

115323 MCT
1403-25

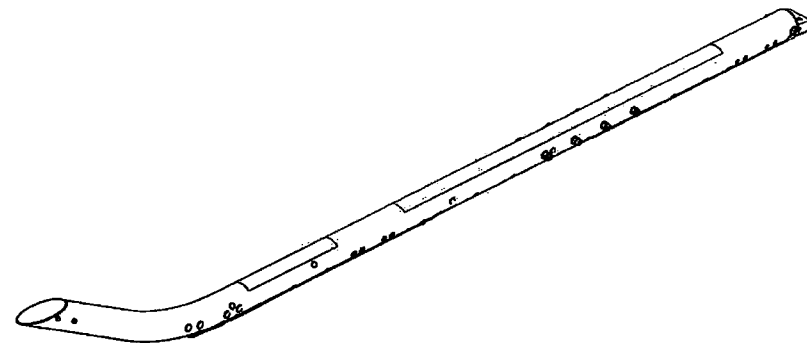
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2013-08-13

| | | | |
|------------|--|----|----------|
| G | CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART 13-276 AND NCR13-2757 | MB | 13.07.11 |
| F | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOOTS; INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | MM | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 13.07.11 | | |

DART AEROSPACE USA, INC.
KENT, WA
REV. G
D2750
SHEET 1 OF 11
TITLE
350 SKIDTUBE ASSEMBLY
NTS
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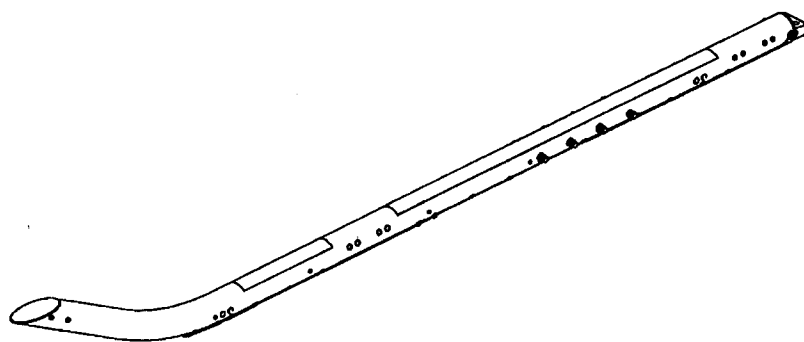
D2750-041 350 SKIDTUBE ASSEMBLY, LH



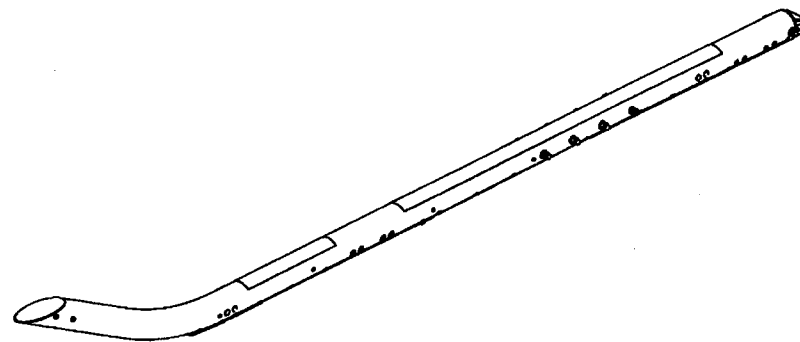
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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| DRAWN | <i>[Signature]</i> | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D2750 | REV. G |
| MFG. APPR. | <i>[Signature]</i> | SHEET 2 OF 11 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 350 SKIDTUBE ASSEMBLY | NTS |
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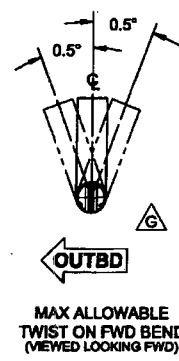
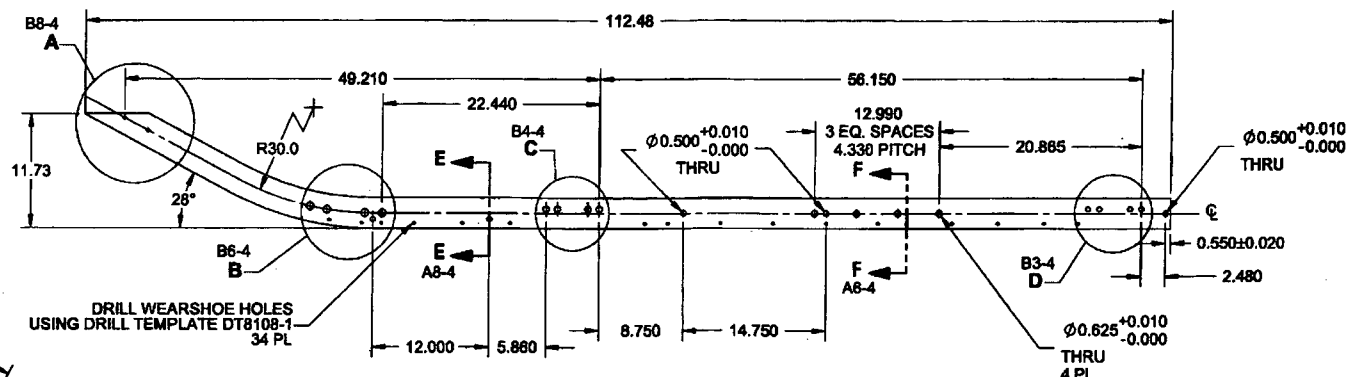
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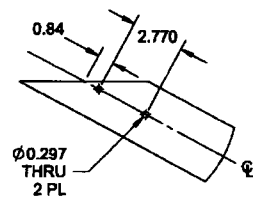
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
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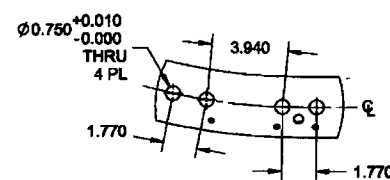
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| DRAWN | <i>[Signature]</i> | KENT, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. G |
| MFG. APPR. | <i>[Signature]</i> | D2750 | SHEET 3 OF 11 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 350 SKIDTUBE ASSEMBLY | NTS |
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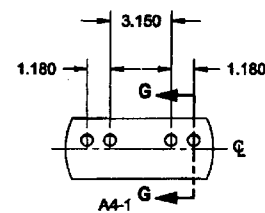
D2750-1 LH SKIDTUBE



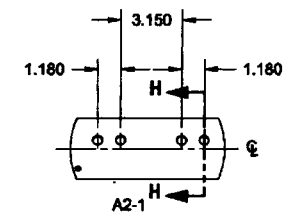
DETAIL A
SCALE 2X



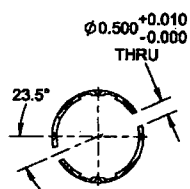
DETAIL B
SCALE 2X



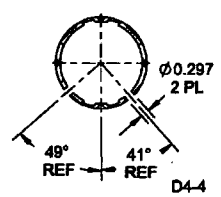
DETAIL C
SCALE 2X



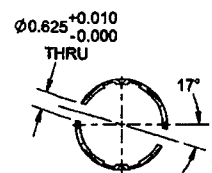
DETAIL D
SCALE 2X



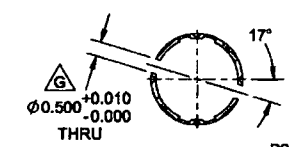
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



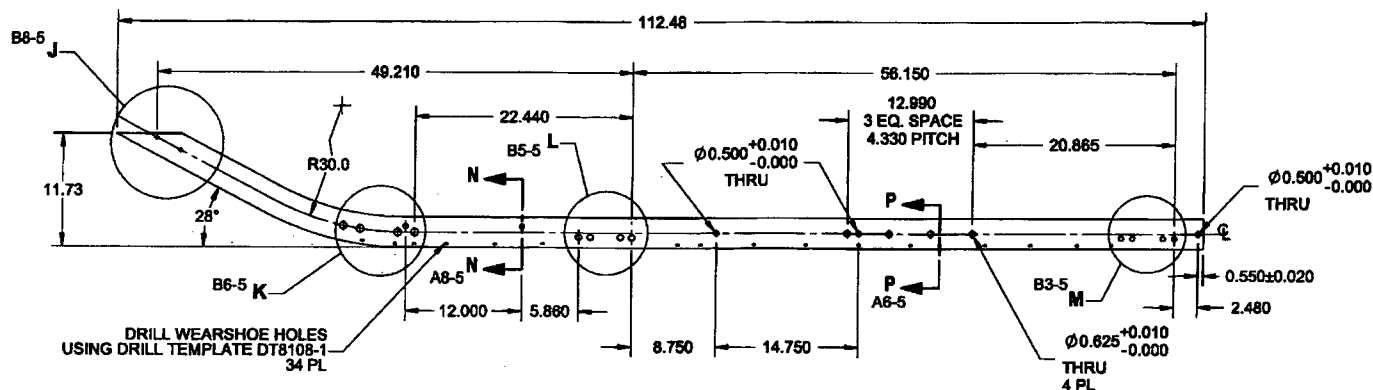
SECTION G-G
SCALE 3X, 4 PL



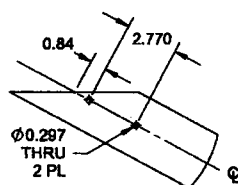
SECTION H-H
SCALE 3X, 4 PL

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2013-08-13

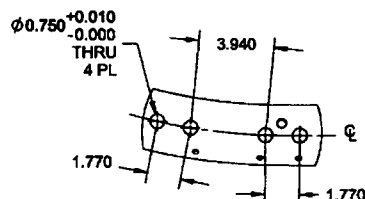
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| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2750 | SHEET 4 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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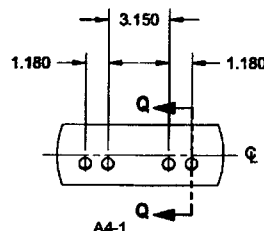
D2750-2 RH SKIDTUBE



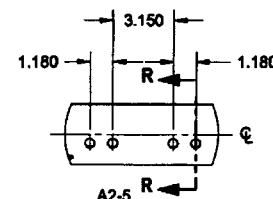
DETAIL J
SCALE 2X



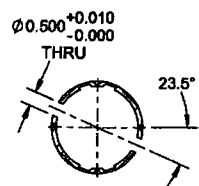
DETAIL K
SCALE 2X



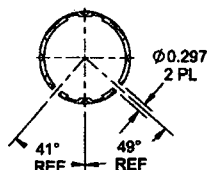
DETAIL L
SCALE 2X



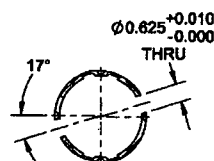
DETAIL M
SCALE 2X



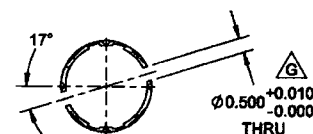
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



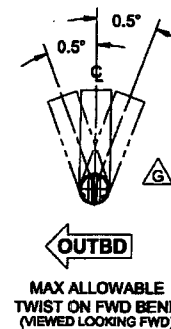
SECTION Q-Q
SCALE 3X, 4 PL








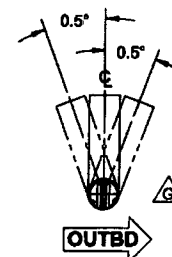
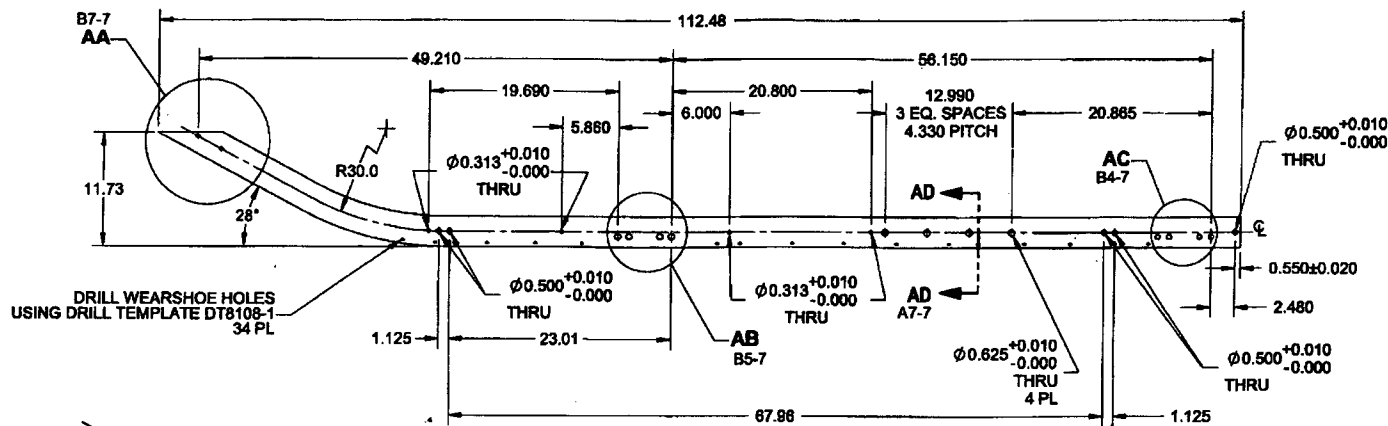
SECTION R-R
SCALE 3X, 4 PL

| | | | |
|------------|----------|--|---------------|
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| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2750 | SHEET 5 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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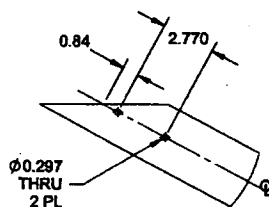
RELEASED
2013-08-13



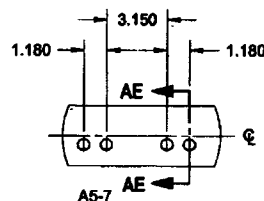
| | | | |
|------------|---|---|---------------|
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| DRAWN |  | KENT, WA | REV. 0 |
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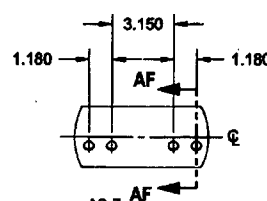
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



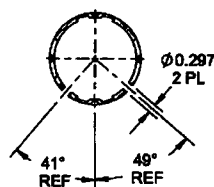
DETAIL AA
SCALE 2X



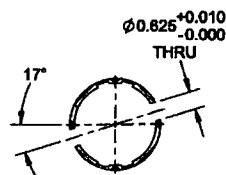
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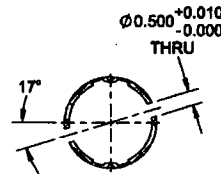
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

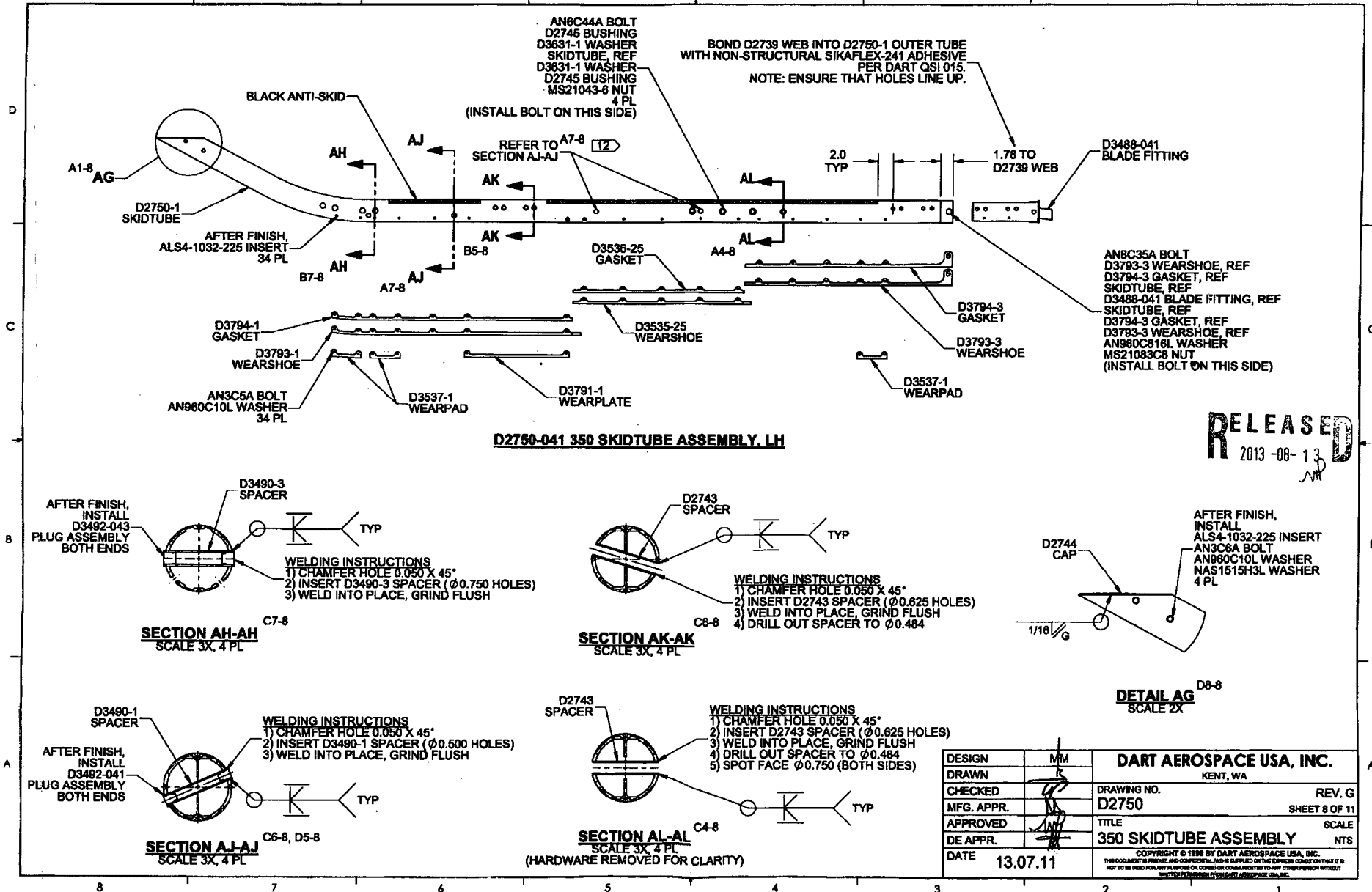


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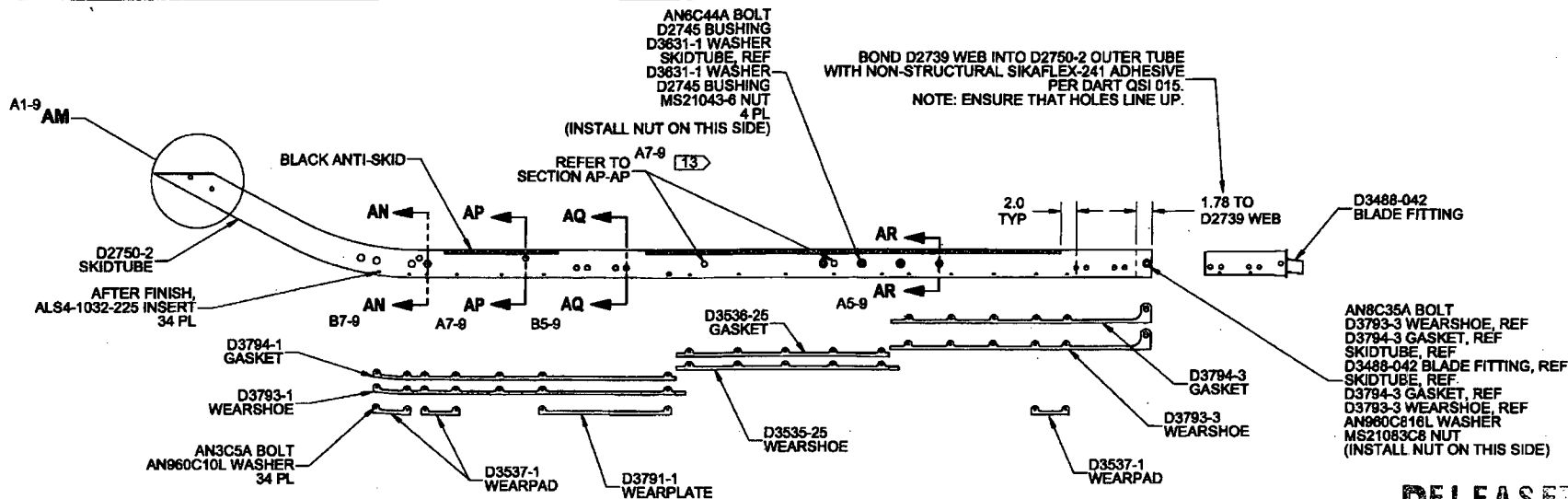
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8 7 6 5 4 3 2 1

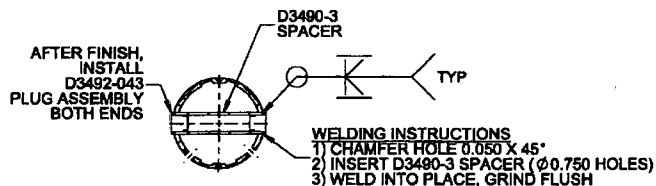


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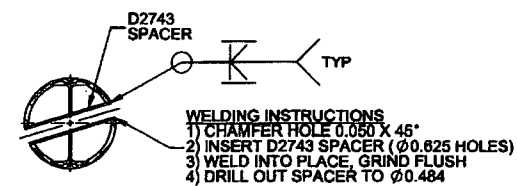


D2750-042 350 SKIDTUBE ASSEMBLY, RH

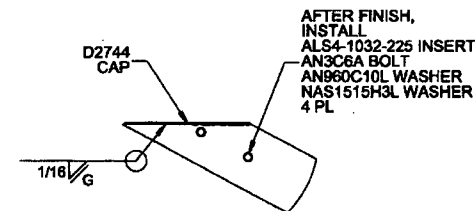
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2013-08-13



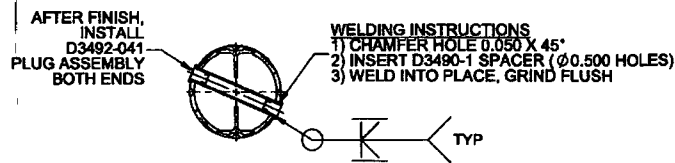
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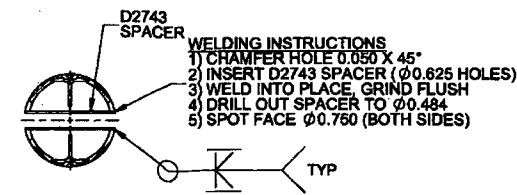
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X

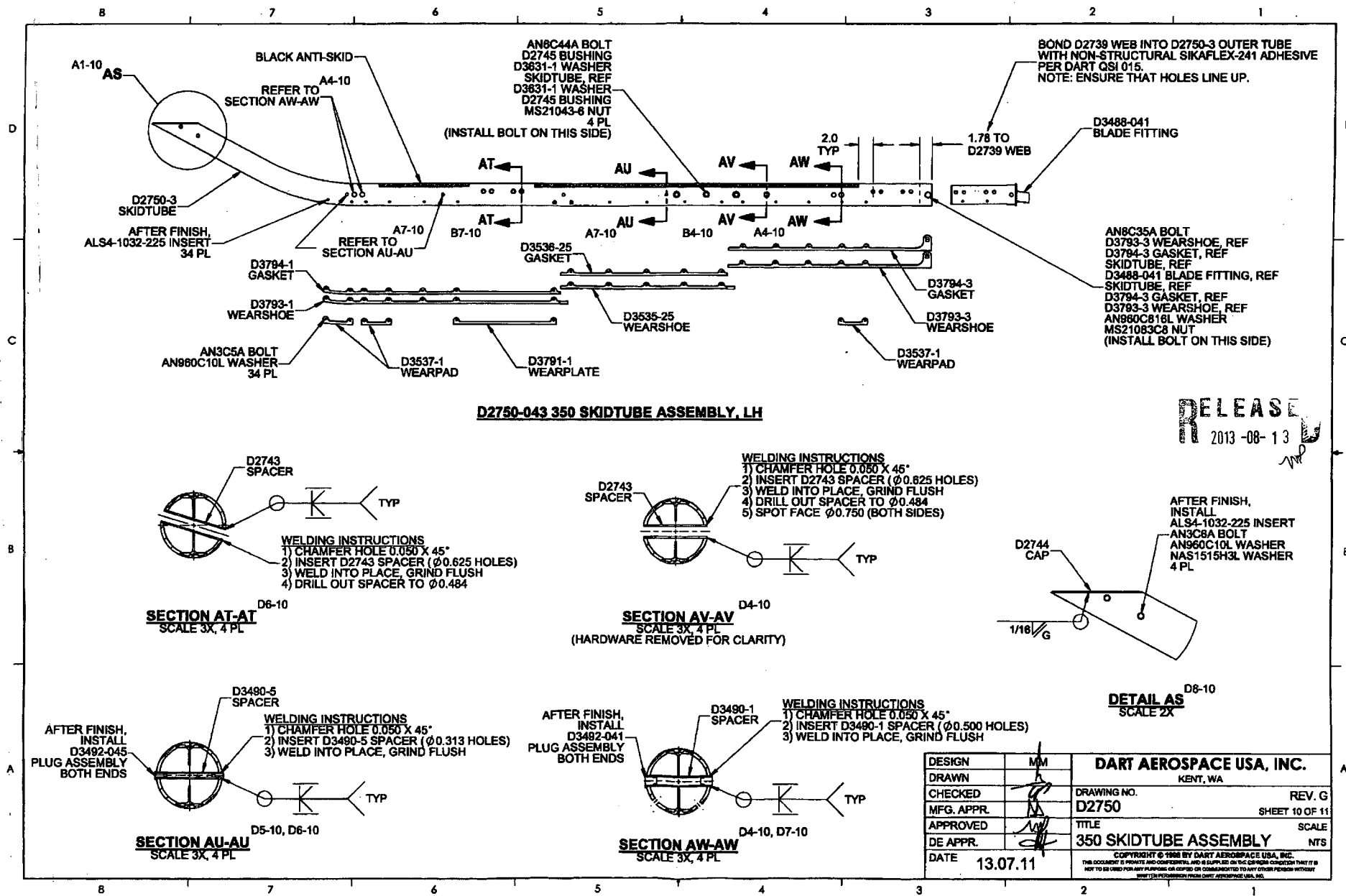


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SCALE 3X, 4 PL

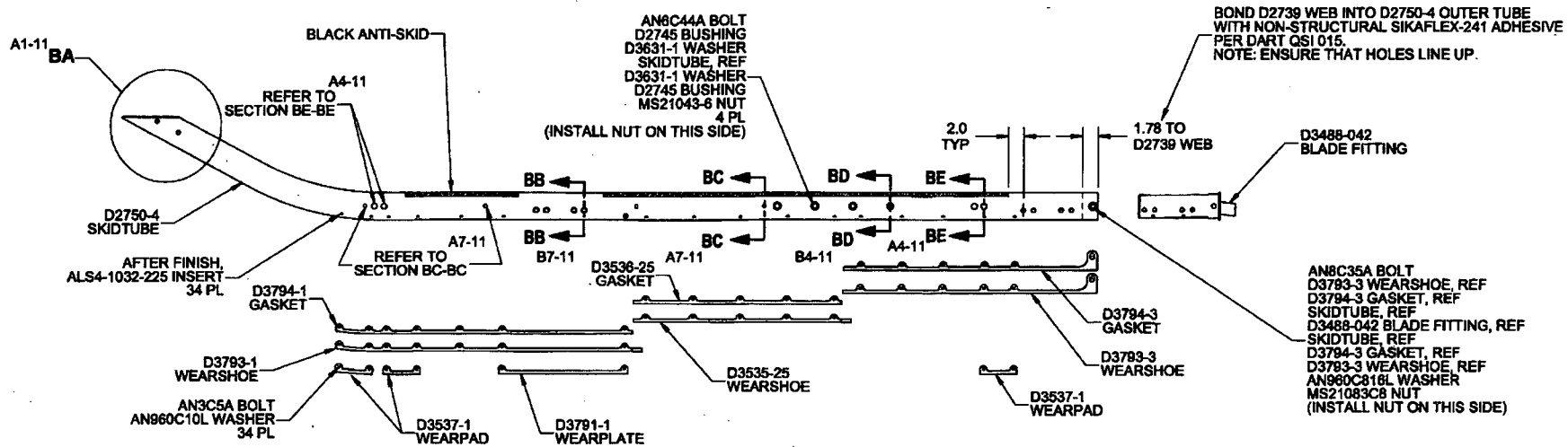


SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

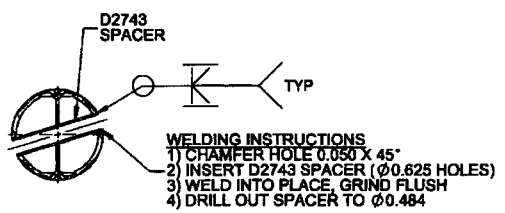
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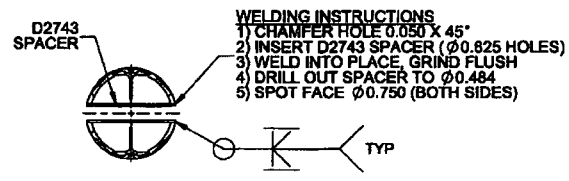
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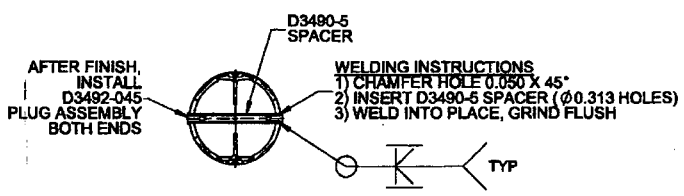
D2750-044 350 SKIDTUBE ASSEMBLY, RH



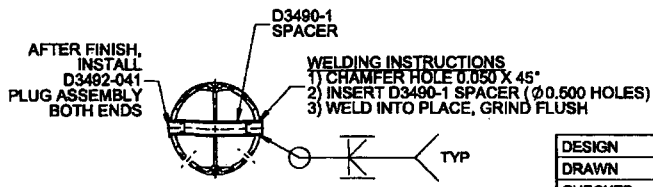
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SCALE 3X, 4 PL



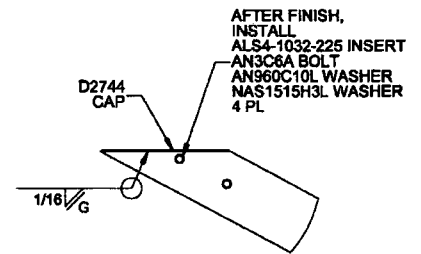
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

| | | | |
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